

Date: Tuesday, 12/20/2005 3:20:04 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY RH
 Job Number : 25301
 Estimate Number : 10799
 P.O. Number : N/A Part Number : D350600142
 This Issue : 12/20/2005 S.O. No. : N/A Drawing Number : D3186 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : 12/20/2005 Type : SMALL /MED FAB Drawing Revision : A1
 Previous Run : 24556 Material : N/A
 Due Date : 1/20/2006 Qty: 1 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE COMMENT ABOVE USER & DATE
 Comment : Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K
 J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-142 CHG002

DA 06/01/30 (1)

2.0 25301A SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

3.0 25301B SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR RH

4.0 D31872 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2 Floor ~~B22929~~ B25409

1 D3186-2 DOOR (REF) 25301B

1 D3188-2 BODY (REF) 25301A

5.0 ALS41032130 Insert



Comment: Qty.: *28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 ALS4-1032-130 Insert M18293

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:20:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-2. Open holes in floor to Ø0.297". Install inserts as per Dwg D3188.

ml 06/05/10

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



DONT Need inspect Here

PTO

Comment: INSPECT WORK TO CURRENT STEP

N/A ml 06/04/12

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3187-2 as per Dwg 3187

2-Deburr D3187-2

ml 06/04/10

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06-05-25 (1)

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-05-16 (4)

11.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-05-16

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-25 (1)


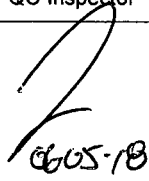
13.0	D2986	Black Neoprene foam .125
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Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/12	7	Permanent Change Don't need inspect QC 5. Take out		ml			 BCP42	 0605-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Date: Tuesday, 12/20/2005 3:20:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.62SF D2986

Neoprene Foam

B24628

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

4100008

m16194

SAD

06:05:17

PTD

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Don't need inspect here
W/A m16194

PTD

16.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2179 Hinge Bracket Plate

B21490

17.0

D2219

Door Prop Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2219 Door Support Bracket

B14027

18.0

D2228

Backing Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2228 Backing Plate

B14028

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

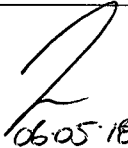
Qty Part Number

Description

Batch


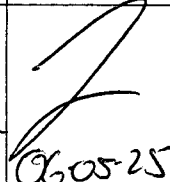


3 D2237 Strike Plate

B24561

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/04/12	15	Don't need This QC 5. Take out Ignore Permanent change. Move after step 43	ml				 060518	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-18	14	Neoprene was glued onto the wrong side of the floor. Human error. Floor is for A L H.		Identify & stock floor as per A L H in composite Ass'y, replace, and fabricate floor.	SAD 060525	 060525		 060518

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D2464	3/4 Seal
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Comment: Qty.: 10.9305 f(s)/Unit Total : 10.9305 f(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2464-125"	neoprene Seal	B25153
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21.0	D2586	Door Latch
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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3	D2586	Latch	B25050
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22.0	D2588	Bracket Mounting channel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2588	Latch	B21509
---	-------	-------	--------

23.0	D2589	Keys, Key Chain
------	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2588	Mounting Channel	B23083
---	-------	------------------	--------

24.0	D2621	Latch Plate
------	-------	-------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

3	D2621	Latch Plate	B22999
---	-------	-------------	--------

25.0	D28571	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2857-1	Hinge Bracket	B26033
---	---------	---------------	--------

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/10	22 prior 23	These steps are mixed Re-do Permanent change.		<i>[Signature]</i>	06-05-31		<i>[Signature]</i> 07/04/10	<i>[Signature]</i> 06-05-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:20:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

26.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Hinge Bracket B26034

27.0	D2977	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2977 Hinge Bracket B14106

28.0	D2978	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2978 Hinge Bracket B14107

29.0	D2982041	Prop Arm Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2982-041 Prop Arm Assembly B24627

30.0	D30153	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock Nut B22365

31.0	A3235020935	Washer - Countersunk
------	-------------	----------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 A3235-020-935 Washer M18332

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:20:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	AN526C832R9	Screw
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN526C832R9 Screw M15602

✓

33.0	AN960JD10	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M19521

✓

34.0	AN960JD516	
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer M15927

✓

35.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 AN960JD8 Washer M11989

✓

36.0	AN960JD8L	Washer
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer M6956

✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:20:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #:	Machine Or Operation:	Description :
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37.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batc

6 MS20426AD4-5 Rivet M3459

PTO

38.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

14 MS21042L08 Nut (or -8) M15003

39.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS21042L3 Nut (or -3) M15539

40.0	MS270390810	Screw
------	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0810 Screw M5865

41.0	MS27039125	Screw
------	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039-1-25 Screw M17570

42.0	SL69BS	Ball Stud
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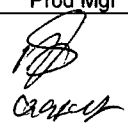
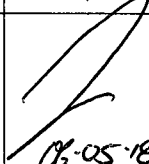
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)


Pick:

Qty Part Number Description Batch

1 SL69-BS Ball Stud M16948

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/12	37	Missing on New w/o <u>ADD Them</u> to Eng 2 Rivets MS 20426 AD 4-6 <u>M2566</u>						 06-05-12

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/05/12
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:20:06 PM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 25301

Part Number: D350600142

Job Number:



Seq. #: Machine Or Operation: Description :

43.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

ml 06/05/10

44.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188-2 & QSI 005 4.4

Batch: *m100 652*

fc 06 05 17

45.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

06-05-18

46.0 K10018 Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 K10018 Spacepod Hardware Kit *26013*

1 D3187-2(Ref) Spacepod Floor *822929 B25404*

06/05/2001

47.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 06/05/2001

48.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location:

PPP Rev: *C*

06/05/2001

49.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/2001

Job Completion



06-05-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/12	43	Need inspect Qc 5 after step 43 Permanent change		ml				
		Part inspected by J 0605-18						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

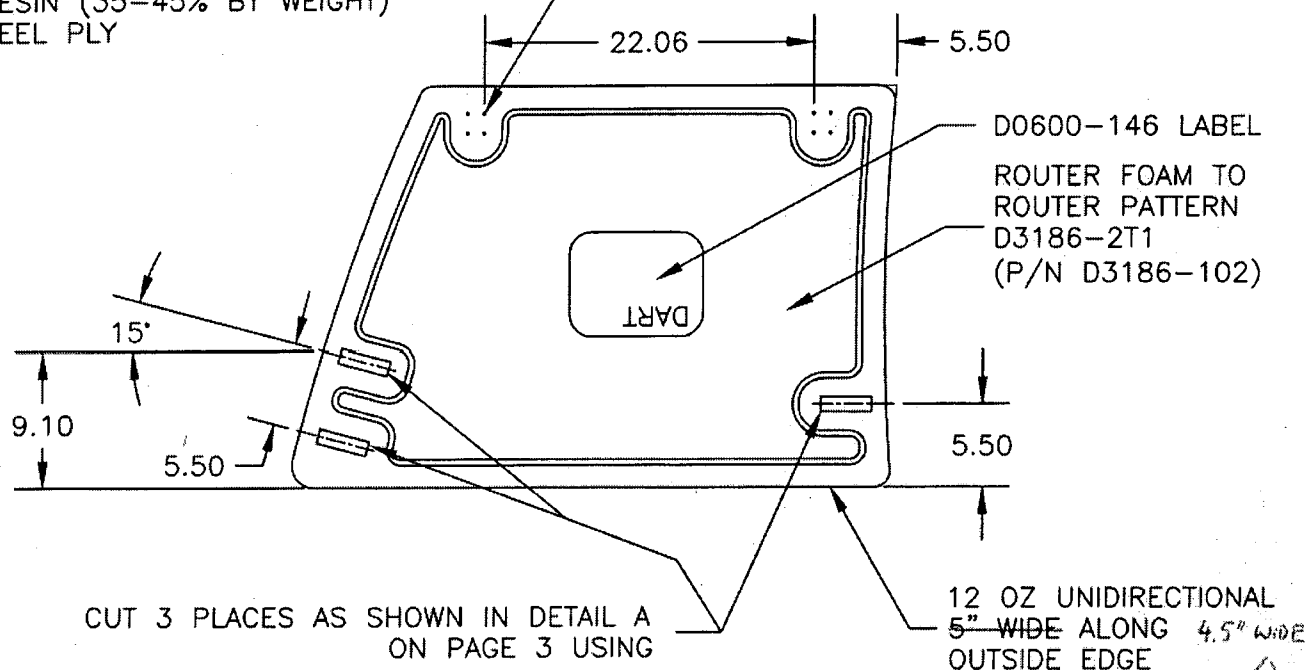
DART

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D3186	REV. A SHEET 2 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8006 (REFER
TO DETAIL B ON PAGE 3)



CUT 3 PLACES AS SHOWN IN DETAIL A
ON PAGE 3 USING

RELEASED
03.04.22

D3186-2**NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

ORIGINAL COPY
TO
ENGINEERING

1. COPY

OVER

2530

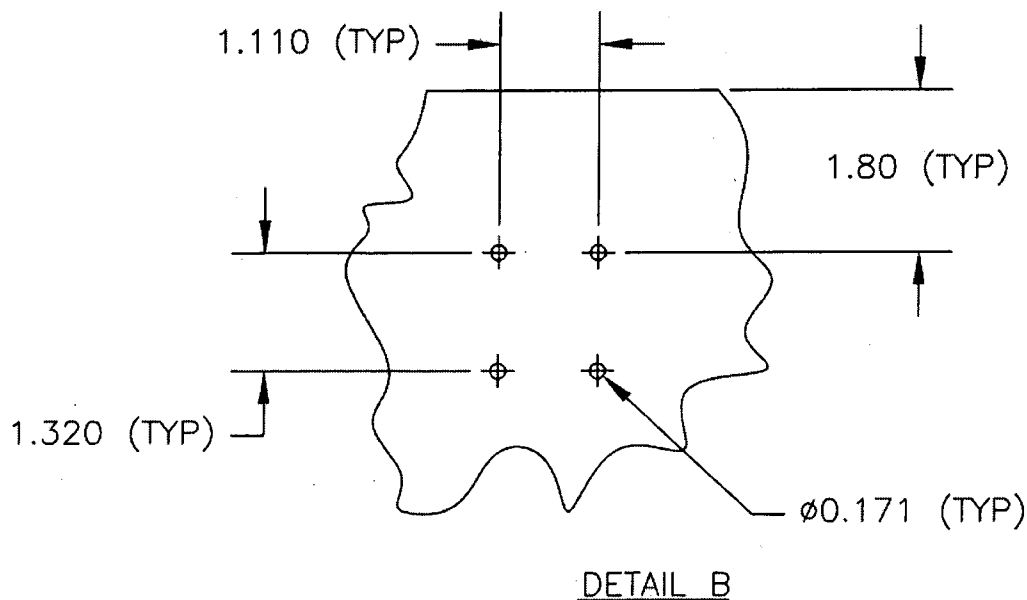
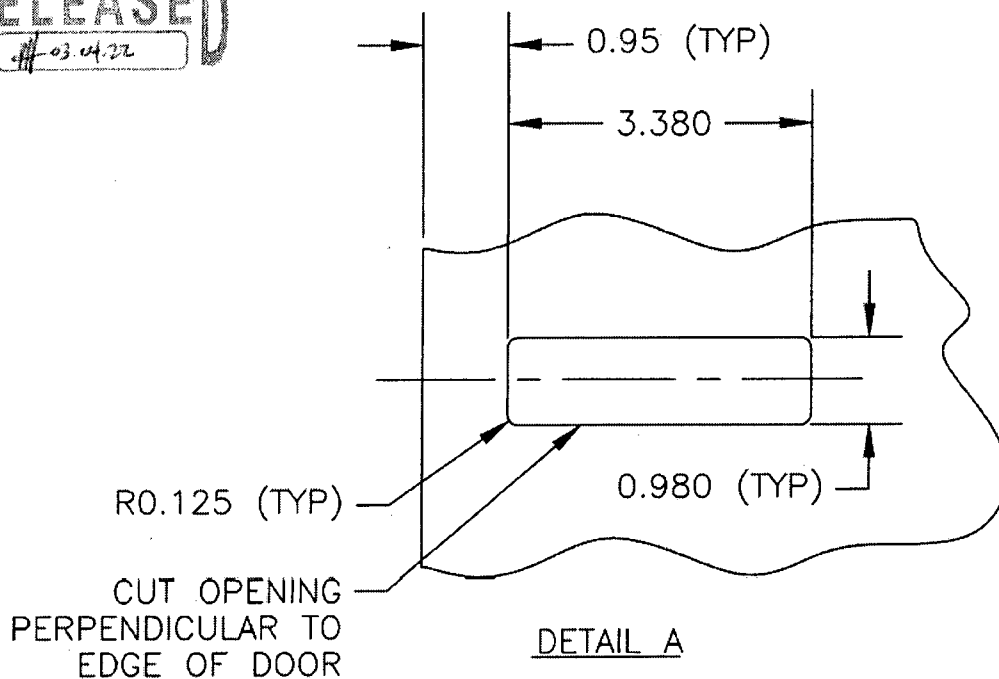
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DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED GP	DRAWING NO. D3186	REV. A SHEET 3 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
03.04.22



NOT COPY
TO
HIND
COPY
MEET

25301

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DESIGN JB	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 1 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	

RELEASED
03.04.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1	DT8003	DT8501
D3188-2	DT8004	DT8502
D3188-3	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

25301

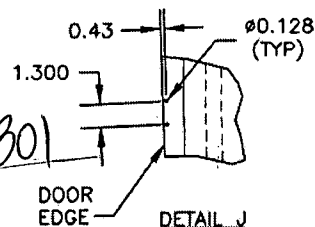
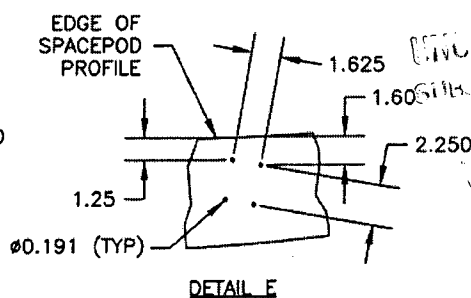
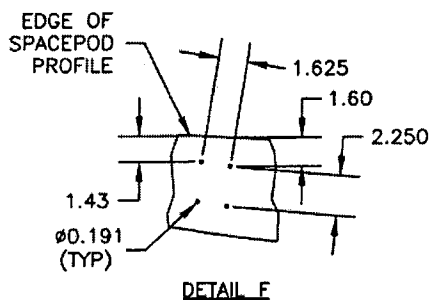
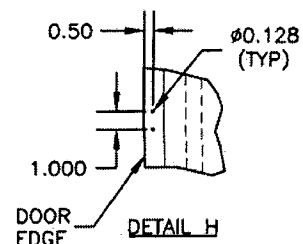
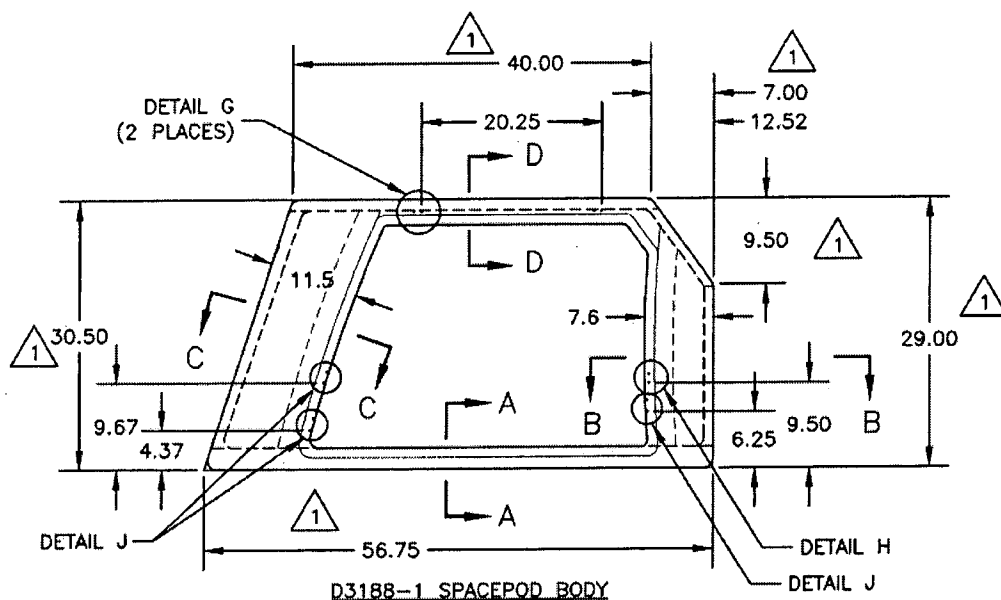
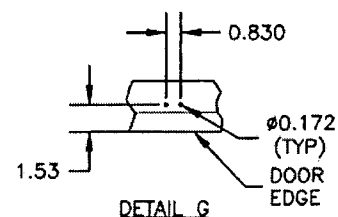
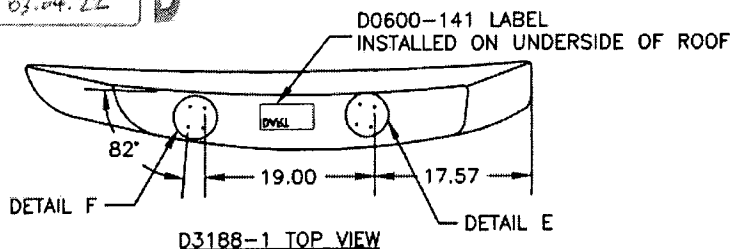
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DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

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03.04.22



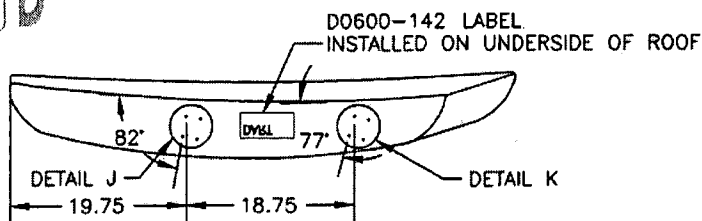
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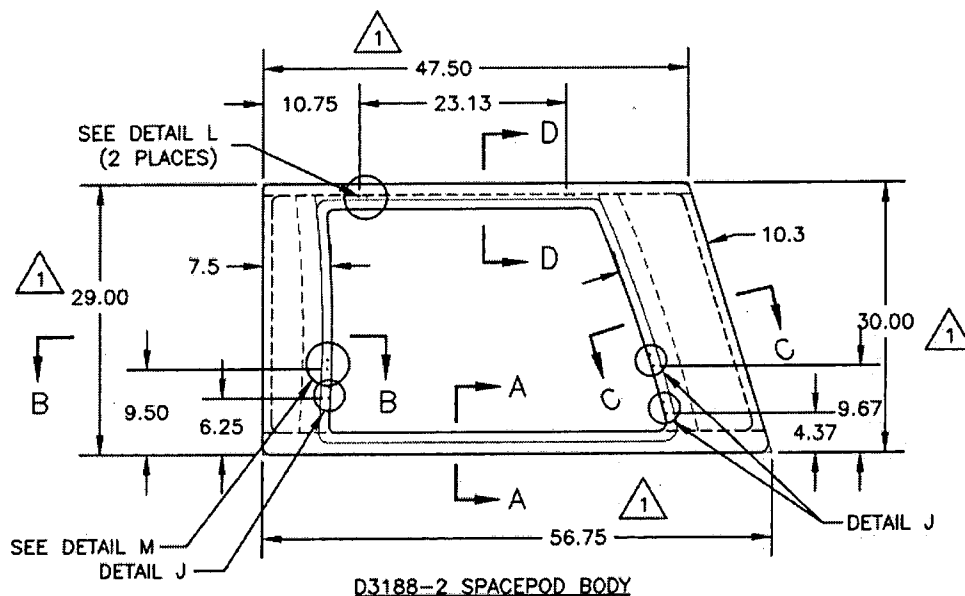
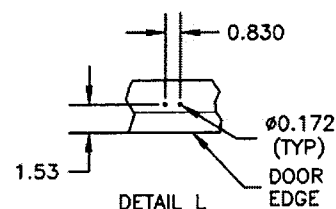


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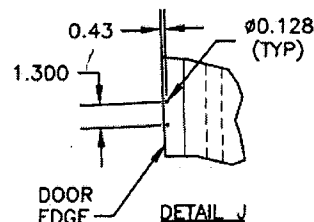
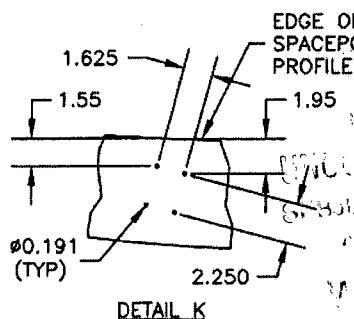
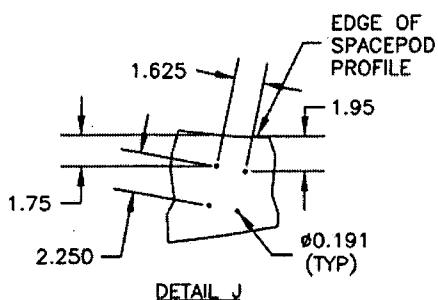
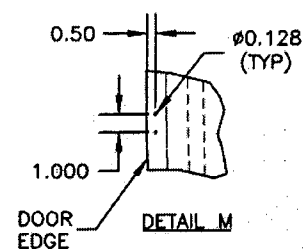
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D3188-2 TOP VIEW



D3188-2 SPACEPOD BODY



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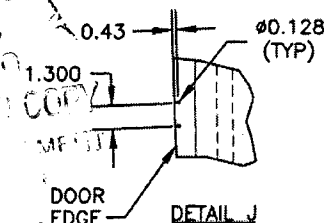
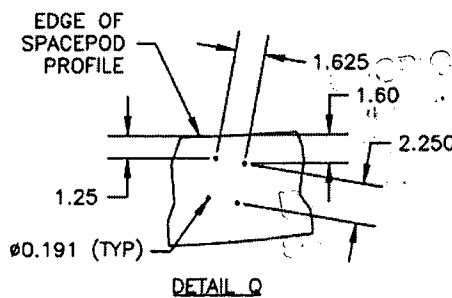
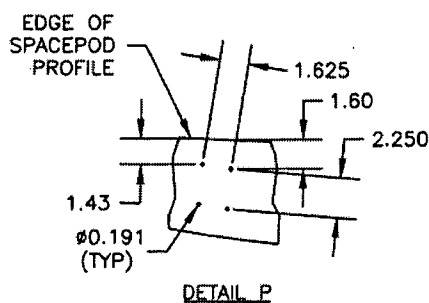
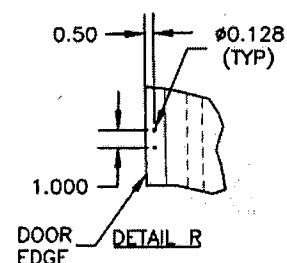
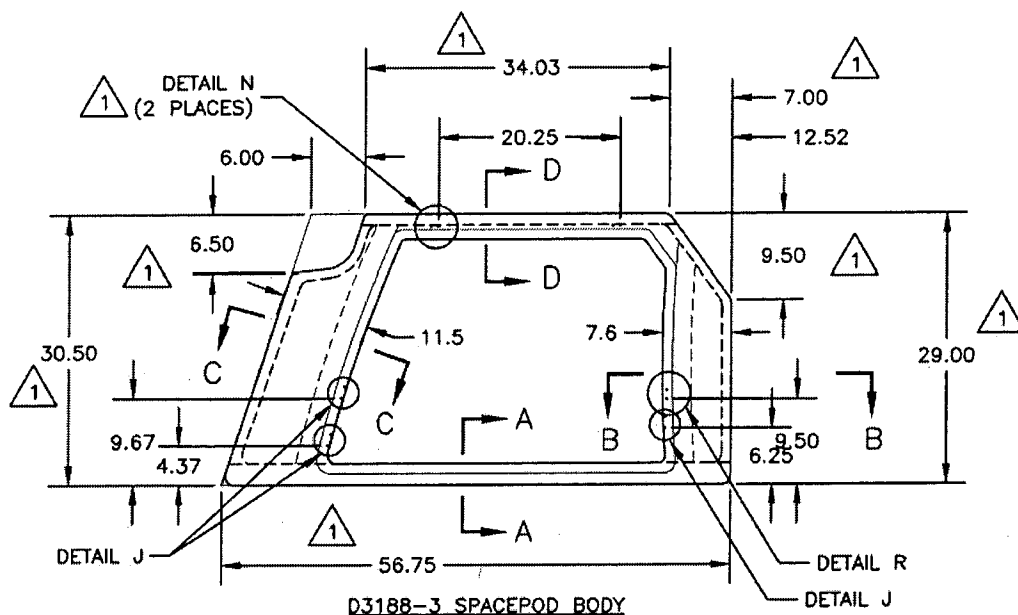
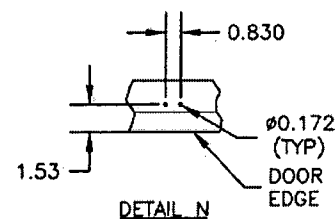
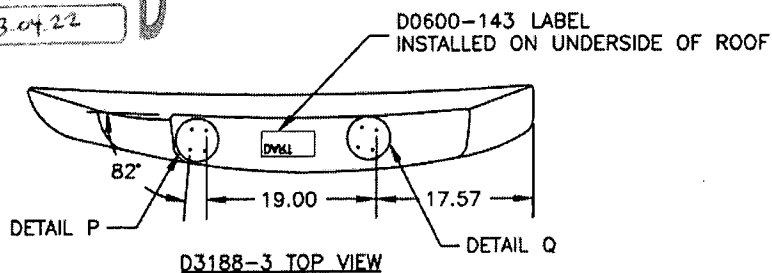
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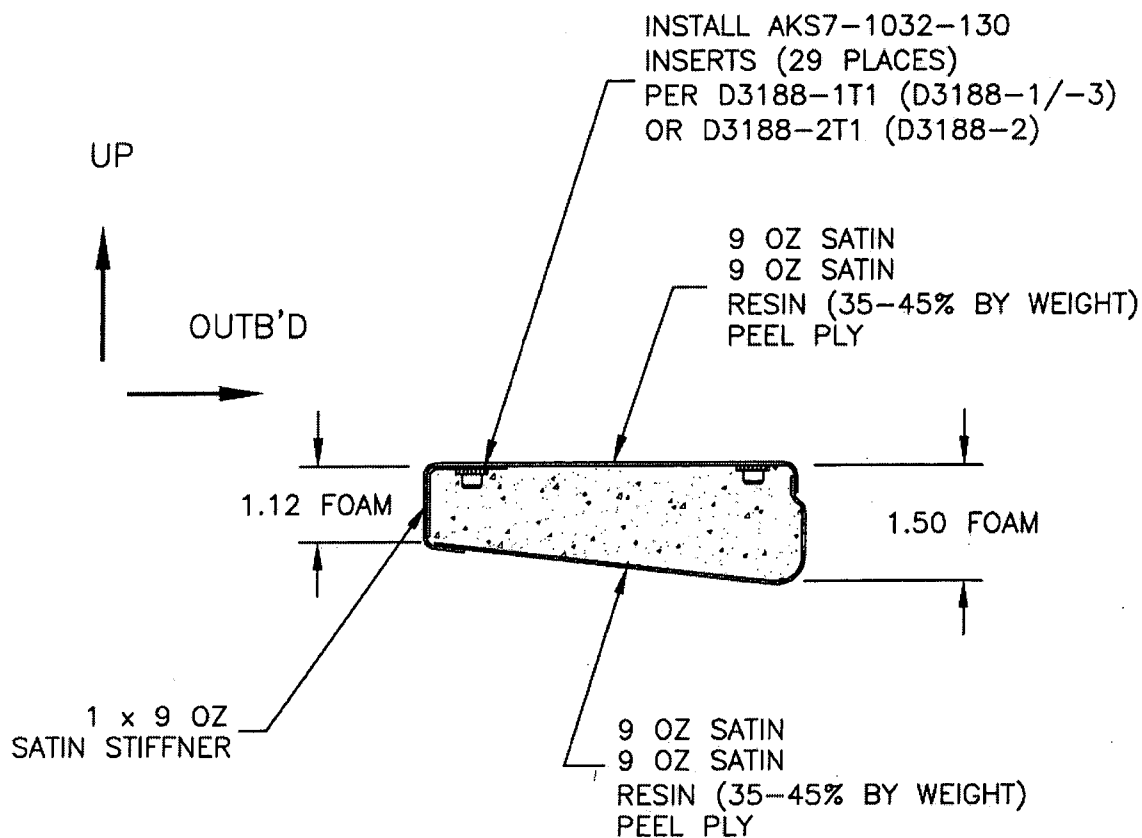
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SECTION A-A
(TYPICAL FLOOR SECTION)

NO. 25301

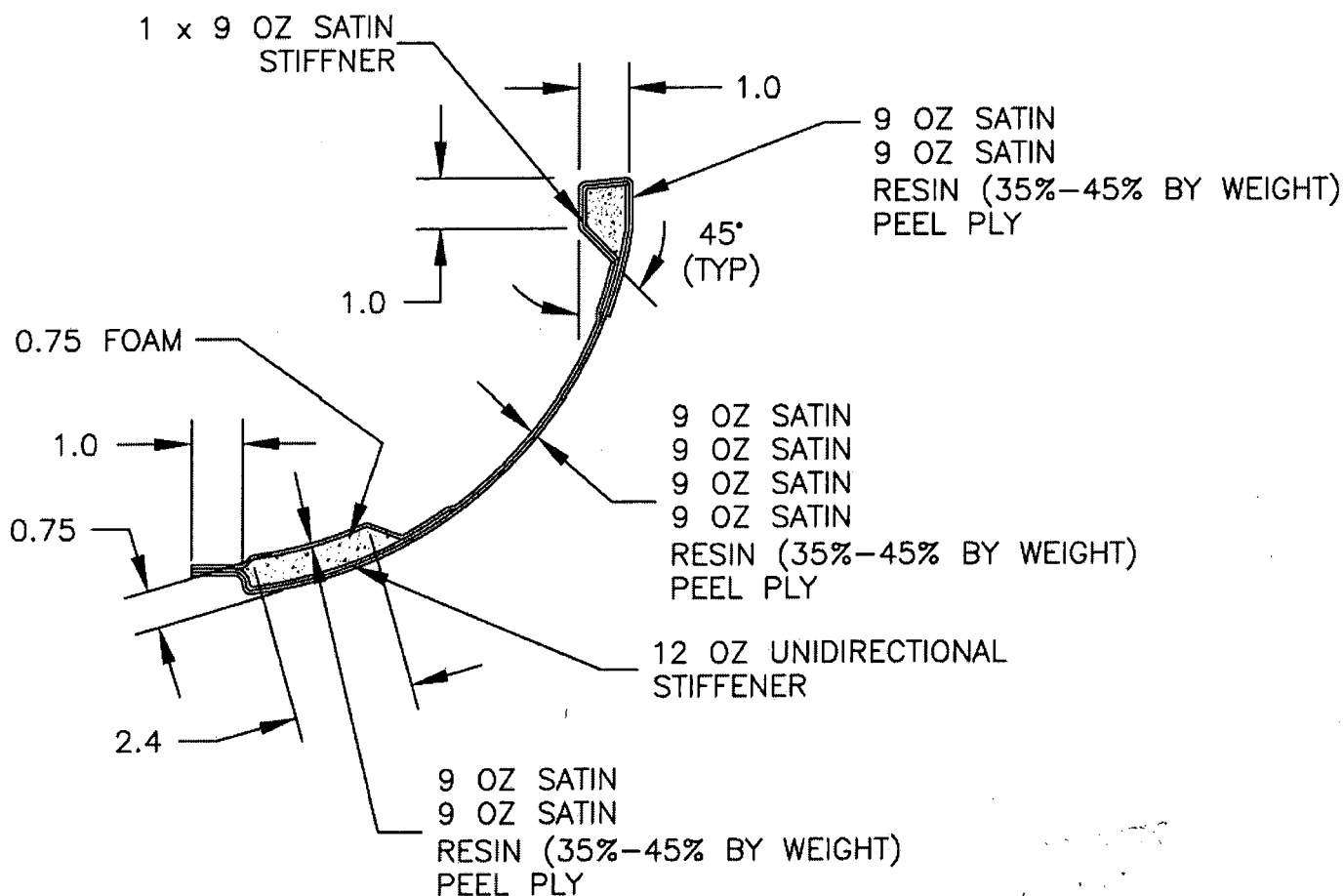
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SECTION B-B
(SECTION C-C SIMILAR)

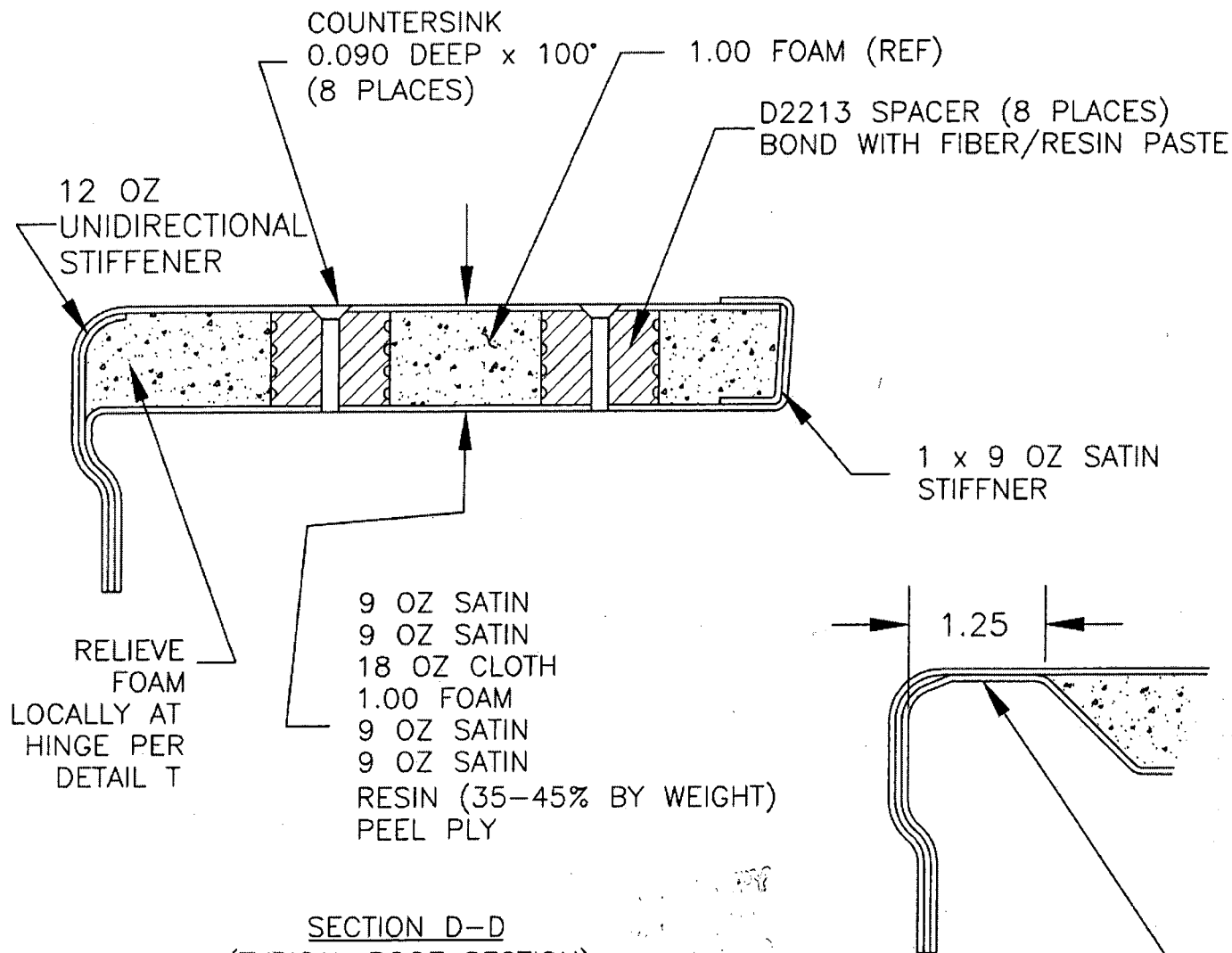
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
03.04.22RELIEVE AS SHOWN
3" LONG CENTERED
ON HINGEDETAIL TW.O.P. - DEB
NO 25301

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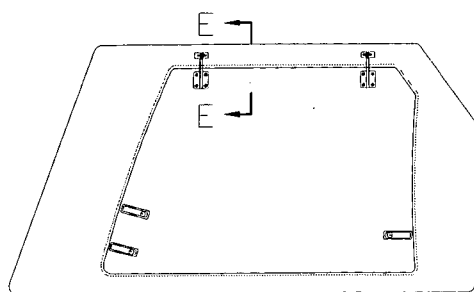


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

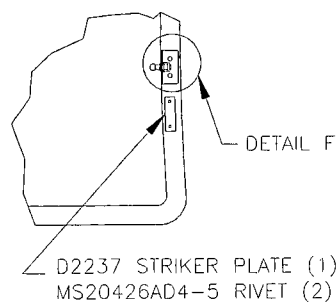


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

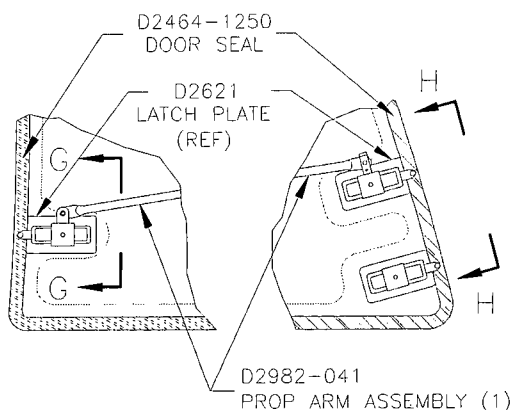
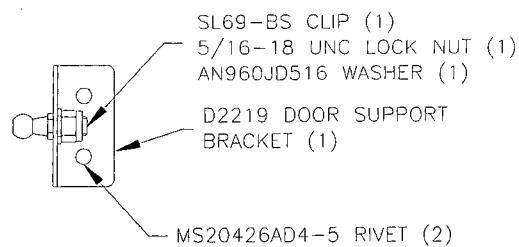


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

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MAY 07 2003

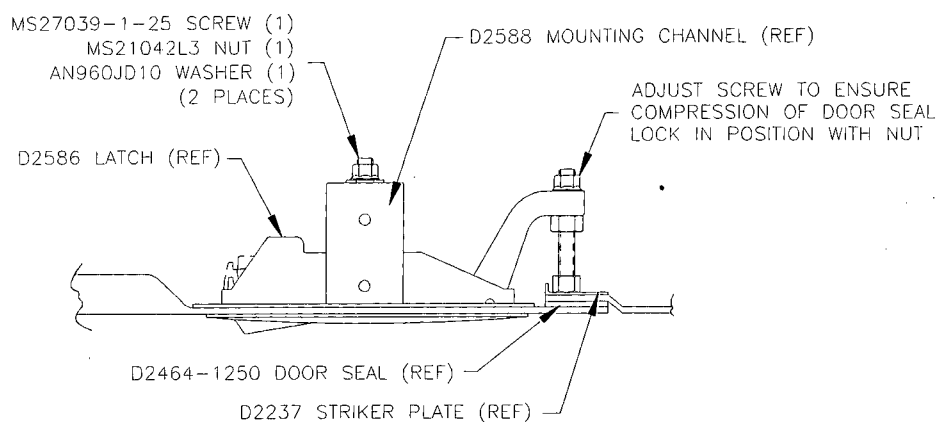
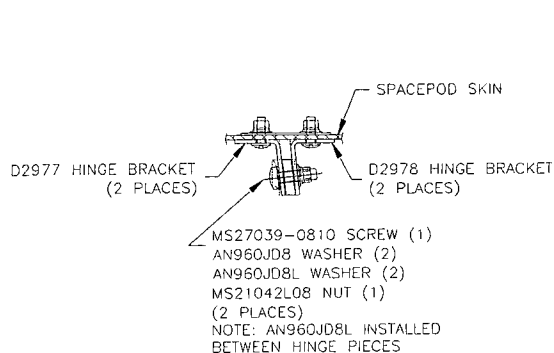
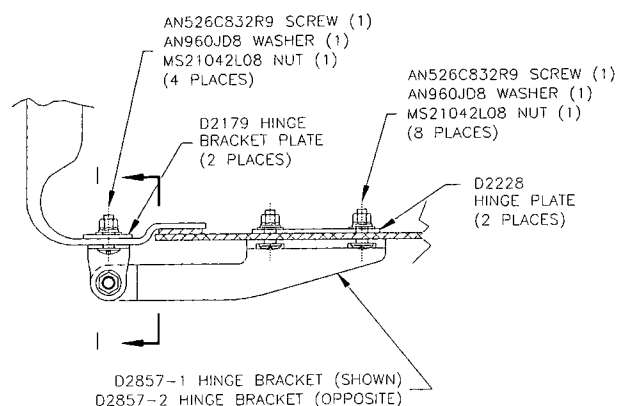


FIGURE 6. TYPICAL LATCH INSTALLATION

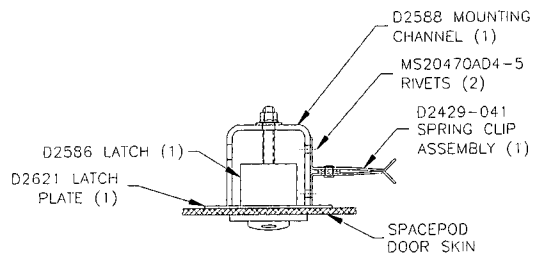
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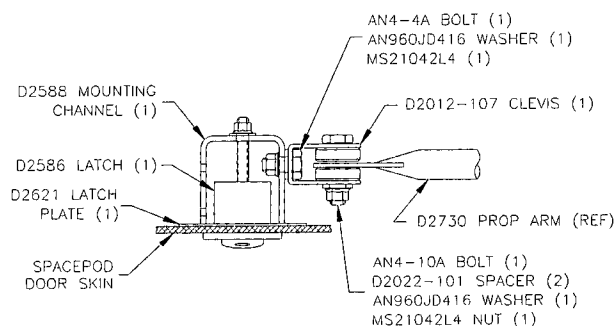
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

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